

Date: Wednesday, 1/31/2007 2:38:48 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 30519-2	Part Number	: D30481
Estimate Number	: 10368	Drawing Number	: D3048 REV. A2
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 1/31/2007 S.O. No. : N/A	Drawing Revision	: A2
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Due Date	: 2/15/2007
Previous Run	: 29093	Qty:	30 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: Est: A 02.11.19 New issue KJ/RF		
	: Est Rev:B Now on Waterjet 06-10-15 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 4 sf(s)/Unit Total : 15 sf(s)  
 2024-T3 .063 sheet  
 Material: 2024-T3 (QQ-A-250/4) 0.063 thick  
 (M2024T3S.063) Batch: 103321

E 07.02.08

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D3048  
 Dwg Rev: A2  
 Prog Rev: A2

E 07.02.08

2-Deburr if necessary

MF. 07-02-09 (3)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

E 07.02.08

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

12/07/02/08 (3)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
 Form on CNC Brake per Dwg D3048

N/A stock as D3048-1F

07/02/08 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   *AD*   Date:   8/10/13  

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 30519 -2

Part Number: D30481

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2  
07/02/13

Job Completion



U 07.02.13

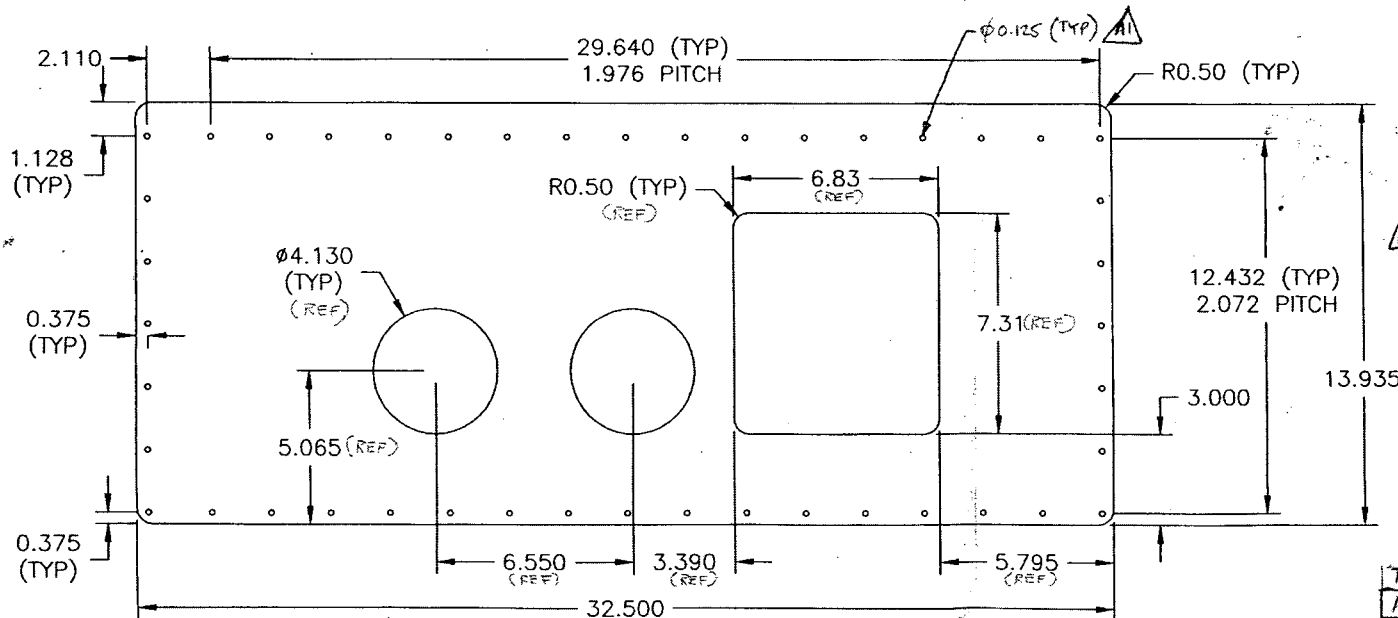
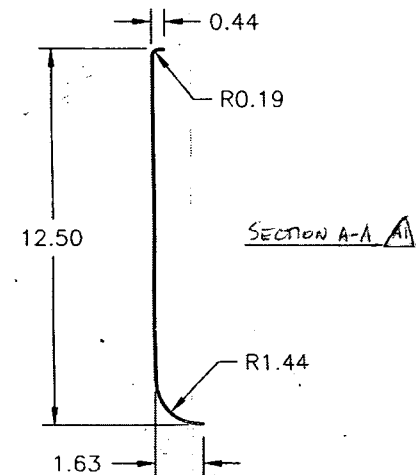
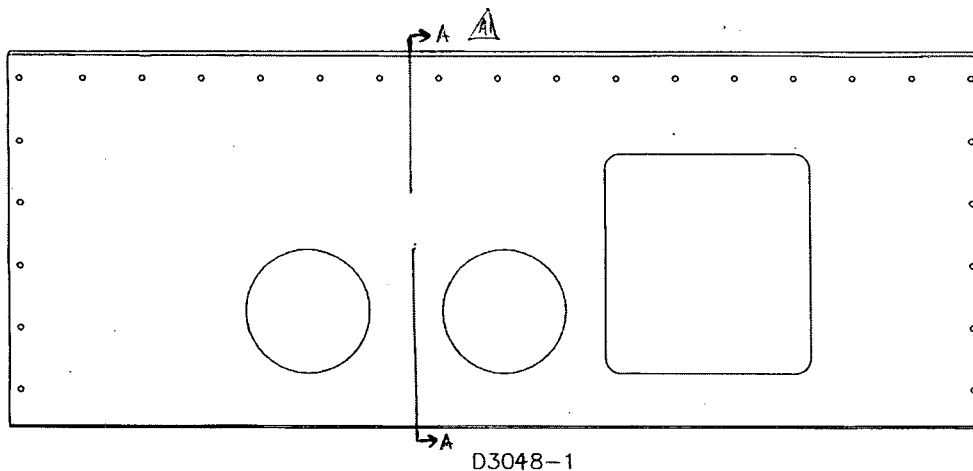
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



MATERIAL: 2024-T3 (QQ-A-250/4)  
0.063 THICK  
FINISH: ACID ETCH, ALODINE PER DART  
QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

△ CUT-OUTS (3 PLACES) ARE SHOWN FOR REFERENCE ONLY,  
DO NOT CUT.



DESIGN	RF	DATE	01.09.25	REVISION	REMOVE CUT-OUTS
CHECKED	RF	DATE	02.11.20	REVISION	CORRECT DWG ERRORS
DATE	01.09.25	TITLE	NEW ISSUE		
DART		DART AEROSPACE LTD.	HARRISBURG, ONTARIO, CANADA		
DRAWING NO.		D3048	REV. A		
TITLE		DOUBLER	SHEET 1 OF 1		
DATE		01.09.25	SCALE		

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RELEASED  
01.09.27

NO. 30519  
WORK ORDER  
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ENGINEERING  
RETURN TO  
SHOP COPY  
D3048-1 FLAT PATTERN